



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

split

D2521
Job Sheet 199292



Part No: D2521

Job Qty: 20 pcs

Part Name: Individual Bearpaw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/16/19

Job Tracking No:

Due Date: 8/30/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV J IPP Rev:A 08-10-01 New Manufacturing Method JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Purchasing	20 pcs	8/30/19	8/30/19	0.00	0.00	Purchasing - 1		<i>[Signature]</i> AUG 21 2019
							Purchasing - 2		
							Purchasing - 3		
100	Packaging 2-1 - Receive - B4B	20 pcs	8/30/19	8/30/19	0.00	0.00	Packaging 2 - 1 - B4B		<i>[Signature]</i> AUG 21 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 -		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S207788



Part: D2521

Job No: 199292

Serial No/Batch: S207788

Revision: J

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/21/19

						B4B	
						Packaging 2 - 21 - B4B	
						Packaging 2 - 22 - B4B	
						Packaging 2 - 23 - B4B	
						Packaging 2 - 24 - B4B	
						Packaging 2 - 25 - B4B	
						Packaging 2 - 26 - B4B	
						Packaging 2 - 27 - B4B	
						Packaging 2 - 28 - B4B	
						Packaging 2 - 29 - B4B	
						Packaging 2 - 30 - B4B	
						Packaging 2 - 31 - B4B	
						Packaging 2 - 32 - B4B	
						Packaging 2 - 33 - B4B	
						Packaging 2 - 34 - B4B	
						Packaging 2 - 35 - B4B	
						Packaging 2 - 36 - B4B	
110 QC 6	20 pcs	8/30/19	0.00	0.00		QC 6 - 9	
						QC 6 - 68	DAS
						QC 6 - 61	81
						QC 6 - 40	9-89
						QC 6 - 81	DAS
130 HAAS 4 Axis - B4B	20 pcs	8/30/19	1.00	34.72		HAAS - 1 - B4B	52
						HAAS - 2 - B4B	9-89
						HAAS - 3 - B4B	
						HAAS - 4 - B4B	
140 QC 2	20 pcs	8/30/19	0.00	0.00		QC 2 - 1	
						QC 2 - 12	
						QC 2 - 14	
						QC 2 - 17	
						QC 2 - 19	
						QC 2 - 2	
						QC 2 - 20	
						QC 2 - 22	
						QC 2 - 23	
						QC 2 - 25	
						QC 2 - 32	
						QC 2 - 33	
						QC 2 - 35	
						QC 2 - 39	
						QC 2 - 4	
						QC 2 - 40	
						QC 2 - 44	
						QC 2 - 45	
						QC 2 - 48	
						QC 2 - 49	

						QC 2 - 50	
						QC 2 - 51	
						QC 2 - 52	DAS 19/08/28
						QC 2 - 57	52
						QC 2 - 62	9-89
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
150 QC 8	20 pcs	8/30/19	0.00	0.00		QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	19.08-28
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
QC 8 - 47							
QC 8 - 40							
QC 8 - 52							
QC 8 - 23							
QC 8 - 57							
160 Packaging 3-1 - Stock - B4B	20 8 pcs	8/30/19	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	ST479A
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
Plex 8/16/19 12:43 PM Dart.lajeunesse.marie							

THU 8-29-2019
Oscar

					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170 QC 21 - SA	20 pcs	8/30/19	0.00	0.00	QC 21 - SA - 21 →	ST-479A
Thu 8-29-2019 8 Oscar					QC 21 - SA - 70	21
					QC 21 - SA - 53	AUG 29 2019

Part Op 90 - 1-Issue PO: _____ 2-Cut blanks as per D2521_BLANK file.
Descriptions: 100 - Receive & Inspect for Damage & Mat'l Certs.
110 - QC6- All purchased or subcontracted products
130 - (HAAS CNC vertical machine #1) 1-Inspect material for defects or damage
Folio and Dwg D2521 Identify as D2521
140 - (QC2- Inspect parts off machine FAI/FAIB)
150 - (QC8- Inspect parts - second check)
160 - (Identify as per dwg & Stock Location: _____)
170 - (QC21- Final Inspection - Work Order Release)

Raw mat
already @
Dural

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2521P	Individual Bearpaw	20 Ea (1 ea)	90-Purchasing	
MUMWBK		140sf (7sf each)		
			DAS 35 9-89	520787 SIT0014

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Purchasing	D2521P	20	0	0

Part Specifications
Specifications could not be found.

Plex 8/16/19 12:43 PM Dart.lajeunesse.marie



DESIGN	<i>#</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>CP</i>	APPROVED	<i>#</i>	DRAWING NO.	REV. J
				D2521	SHEET 1 OF 3
DATE	06.07.28		TITLE		SCALE
			205 BEARPAW		NTS
A	95.11.28	NEW ISSUE			
B	96.01.11	SHOW BENDING MOVE HOLES			
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING			
D	96.05.14	ADJUSTED BEAR PAW THICKNESS			
E	96.12.18	43.500 WAS 46.750			
F	97.05.07	ADDED REAR POCKET, MOVED HOLES			
G	98.08.06	ADD C'BORE AND CHAMFER EDGES			
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.			
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES			
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE			

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
NOTICE
DER
199292 MWS
19-08-16

RELEASED

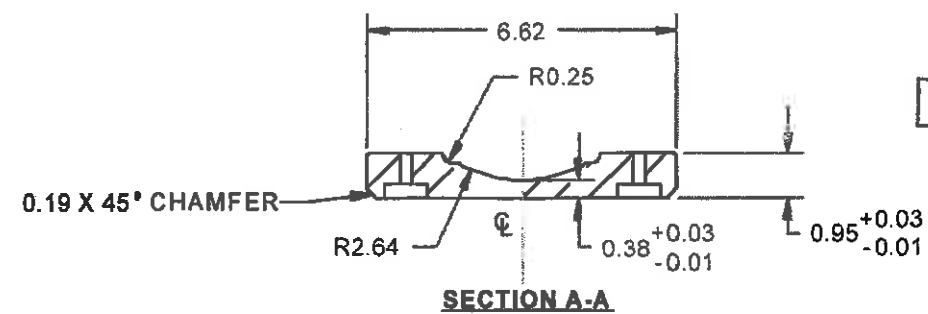
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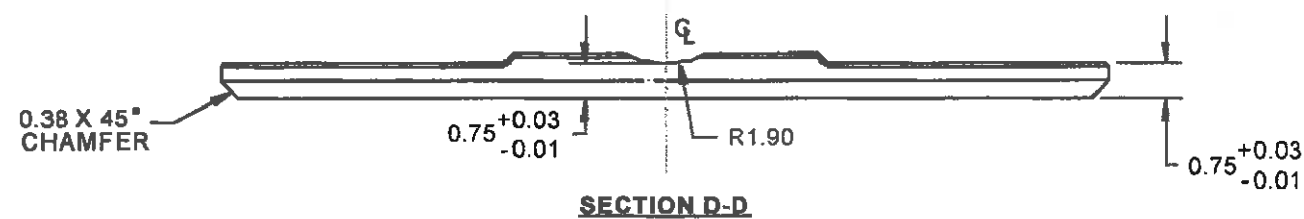
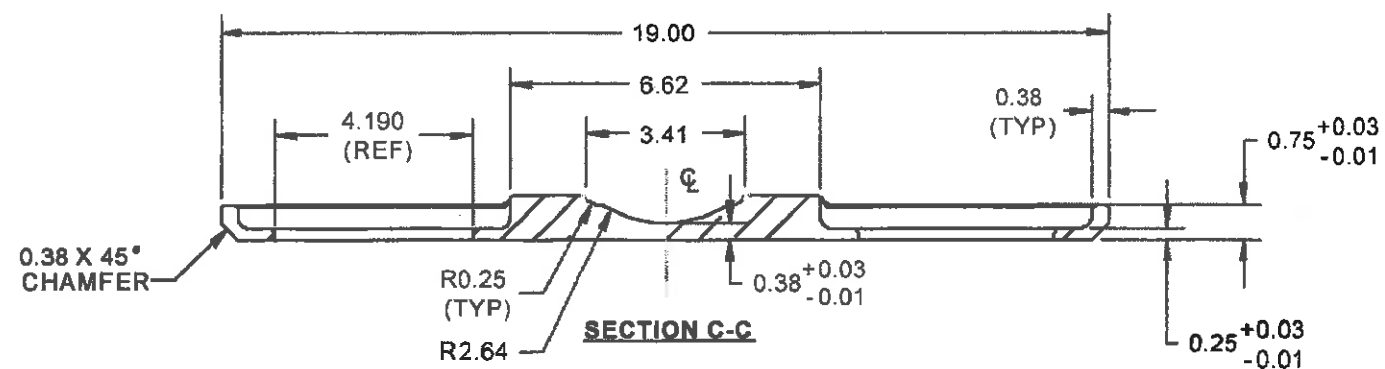
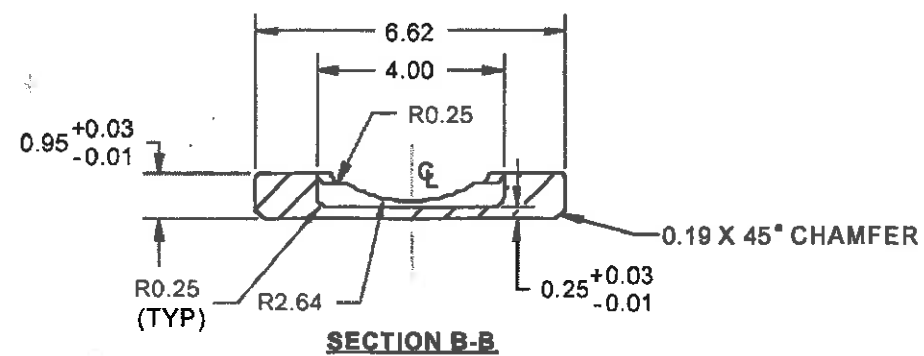
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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J
DATE 06.07.28	TITLE 205 BEARPAW	SHEET 3 OF 3 SCALE 1:4	



RELEASED
06.08.23



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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB044289



Supplier: ACI002-VC Acier Duval Steel 5888 Country Road 17 Plantagenet ON K0B 1L0 Canada Phone: 613-673-5474 Fax: 613-673-4576	PO No: POHB044289 PO Date: 8/19/19 Due Date: 8/26/19 Purchase Order Revision: Revision Date: Ship-To Contact: Guerin, Kimberley Phone: 613-632-5200 Ext: 298 kguerin@dart.aero.ca Pynt Terms: Net 30 Freight Terms: Special Comments:
Ship To: 1270 Aberdeen Street Hawkesbury ON K6A 1K7 Canada Phone: 613-632-5200	

EMMAILED
2019-08-20

Items												
Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199292	D2521P		Individual Bearpaw as per Dwg D2521_Blank File	Firmed	20 X	8/26/19	20 Ea	0 Ea	20 Ea	\$57.77/Ea	\$1,155.40
2	199291	D3075-1P		Bearpaw (Foot Print Only), as per Dwg D3075_blanknest file	Firmed	10 X	8/26/19	10 Ea	0 Ea	10 Ea	\$19.97/Ea	\$199.70
3	199290	D3529-1P		Bearpaw as per Dwg F3529-1_4x8 file	Firmed	18 X	8/26/19	18 Ea	0 Ea	18 Ea	\$23.37/Ea	\$420.66
4	199293	D2432P		Bearpaw 19" X 24", as per DWG D2432_nest7 file	Firmed	8 X	8/26/19	8 Ea	0 Ea	8 Ea	\$35.26/Ea	\$282.08
Grand Total:												\$2,057.84

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance - NOT SUPPLIED

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

A.D.S.

Acier Duval Steel

Fabrication shop: aluminum and stainless steel
plate cutting, bending, rolling and punching services.

Atelier de fabrication: aluminium et acier inoxydable
Service de coupe, pliage, roulage et poinçonnage.

1-866-831-5722

T: 613-673-4574

info@adsindustries.com

5888 County Rd. 17

Plantagenet, ON.

K0B 1L0

Packing Slip:

8024

Aug 21, 2019

1 of 1

Sold to:	Ship to:
Dart Aerospace 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No: POHB041289	Sold By:
Shipped By:	Ship date:
Tracking No:	

Item No	Quantity	Description
Water jet cutting	20	Waterjet cutting only, customer material UHMW 1" black: Individual Bearpaw as per Dwg D2521_Black file, Job 199292. Part#D2521P
Water jet cutting	10	Waterjet cutting only, customer material UHMW 1" black: Bearpaw (Foot Print Only) as per DWG D3075_blacknest file, Job 199291. Part #D3075-1P
Water jet cutting	18	Waterjet cutting only, customer material UHMW 1" black: Bearpaw as per Dwg F3529_4x8 file, Job 199290. Part#D3529-1P
Water jet Cutting	8	Waterjet cutting only, customer material UHMW 1" black: Bearpaw 19" x 24" as per DWG D2432_nest file, Job 199293. Part#D2432P
RECEIVED AUG 21 2019 DART AEROSPACE LTD. 		
Comment: ADS industries = Facebook & Instagram		

DART AEROSPACE LTD		Work Order:	199292
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521 Rev: J		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	0.261	✓		G.P.	
B	0.90	0.96	0.930	✓		Ver	
C	0.27	0.330	0.310	✓		Ver	
D	0.470	0.530	0.500	✓		Ver	
E	21.740	21.760	21.750	✓		TAPE	
F	0.72	0.780	0.750	✓		Ver	
G	0.35	0.410	0.380	✓		Ver	
H	11.490	11.570	11.500	✓		TAPE	
I	3.41	3.47	3.440	✓		Ver	
J	11.790	11.810	11.800	✓		TAPE	
K	9.47	9.53	9.500	✓		TAPE	
L	7.190	7.210	7.200	✓		Ver	
M	6.910	6.970	6.940	✓		Ver	
N	44.47	44.530	44.500	✓		TAPE	
O	6.590	6.650	6.620	✓		Ver	
P	0.940	0.980	0.970	✓		Ver	
Q	18.97	19.03	19.00	✓		TAPE	
R	0.350	0.410	0.380	✓		Ver	
S	0.740	0.780	0.760	✓		Ver	
T	0.240	0.280	0.265	✓		Ver	
U	0.370	0.410	0.395	✓		Ver	
V	0.740	0.780	0.770	✓		Ver	
W	0.740	0.780	0.760	✓		Ver	

Measured by: ^{DAS} 52	Audited by: ^{DAS} 20	Prototype Approval:	N/A
Date: 9-89 19/08/27	Date: 19-08-28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM	